




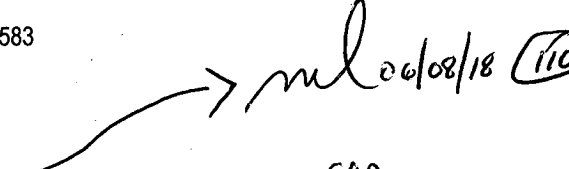








Date: Friday, 21/07/2006 12:04:08 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH BRACKET
Job Number	: 28018		
Estimate Number	: 10994		
P.O. Number	: N/A	Part Number	: D2583
This Issue	: 21/07/2006 S.O. No. : N/A	Drawing Number	: D2583 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 28018	Material	: N/A
Written By	:	Due Date	: 12/08/2006
Checked & Approved By	:	Qty:	100 Um: Each
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM Est: D 06.07.21 Waterjet EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
			
Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) Batch: M17835 (58) M15982 6 M15982 (52) 110			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D2583 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary  SAD 06:08:14 110			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 06:08:15 110			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK 06-08-20 110 cant			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Deburr Form on CNC Brake as per-Dwg D2583 2B 06/08/24 110			

Date: Friday, 21/07/2006 12:04:09 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 28018

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD

06:09:02

110

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

06 09 06

110

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/9/8

110

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 190

6/9/8

110

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/11

Job Completion








U 06-09-11

PTO →

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH BRACKET
Job Number	: 28018		
Estimate Number	: 10994		
P.O. Number	:	Part Number	: D2583
This Issue	: 7/21/2006 S.O. No. :	Drawing Number	: D2583 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 25326	Material	:
Written By	: <u>HJ</u>	Due Date	: 8/12/2006 Qty: 100 Um: Each
Checked & Approved By	: <u>HJ 06.07.21</u>		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM		

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
		
Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) Batch: _____		
2.0	SHEAR	SHEAR
		
Comment: SHEAR Cut blank: 4.000" x 2.130" Grain offset 10° along 3.188"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2583		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	BRAKE NC	NC BRAKE
		
Comment: NC BRAKE Deburr Form on CNC Brake as per Dwg D2583		

$\rho_{10} \rightarrow$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-28	S.0	ADD QCS to inspect bending. Perm. Change	E	06-08-28			
	S.1	QCS Inspect work.	J	06-08-28	110		06-08-28

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 06/05/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 7/21/2006 7:37:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 28018

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Handwritten signature and date: 7-26-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

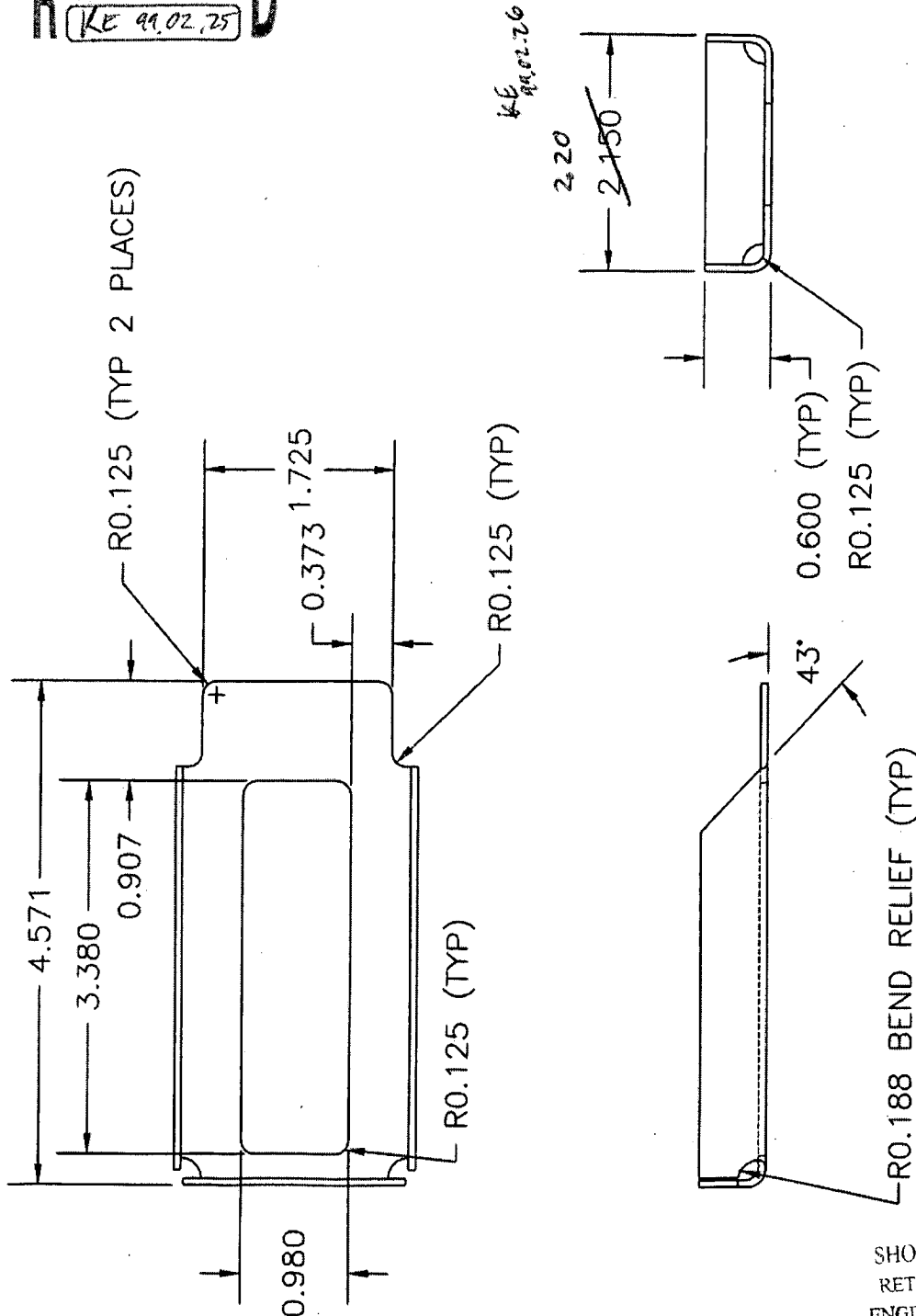
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN MIKE M.	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2583	REV. B SHEET 1 OF 1
DATE 99.02.22		TITLE LATCH BRACKET	SCALE 2:3
A	96.07.10	NEW ISSUE	
B	99.02.22	CHANGE OF FINISH (PER TSR A887)	

RELEASED
KE 99.02.25

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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ENGINEERING

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WORK ORDER
NO. 28018